

Date: Friday, 6/6/2008 7:52:40 AM  
 User: David Duval

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LATCH ASSEMBLY
Job Number : 05031	
Estimate Number : 13370	
P.O. Number :	Part Number : D3589041
This Issue : 6/6/2008 S.O. No. :	Drawing Number : D3589 PROTO 08.06.06
Prsht Rev. : NC	Project Number : VR0004
First Issue : // Type : R & D LG FAB	Drawing Revision : PROTO
Previous Run :	Material :
Written By : <u>08/06/06</u>	Due Date : 6/13/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A new issue 08-06-05 DD verified by:ec	

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D35891	ARM
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 ARM  
 batch: B05030

PD 08-06-06

3.0	D35893	ARM GUIDE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4 2.0000 Each(s)  
 ARM GUIDE  
 batch: B05024

PD 08/06/06

4.0	D35897	AFT GUIDE PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 AFT GUIDE PLATE  
 batch: B05027

PD 08-06-06

5.0	D35899	FWD GUIDE PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 FWD GUIDE PLATE  
 batch: B05028

PD 08-06-06

Date: Friday, 6/6/2008 7:52:40 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 05031

Part Number: D3589041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D358911	FWD GUIDE PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

FWD GUIDE PLATE

batch: B05029

PD 08-06-06

7.0	D358913	LUG
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LUG

batch: B05025

PD 08-06-06

8.0	D358915	LINK
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LINK

batch: B055026

PD 08-06-06

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

\*\*\* ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS\*\*\*

4- using door as a template install parts on door and weld as per dwg D3589 QSI004

304 Stainless Steel Rod Batch: M105524

PD 08-06-06

10.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

11.0	QC5	INSPECT WORK TO CURRENT STEP
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ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24

Date: Friday, 6/6/2008 7:52:41 AM  
User: David Duval

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 05031

Part Number: D3589041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 AN960JD4 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M11735

*[Signature]*

14.0 MS203921C7 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

batch: M118822

*[Signature]*

15.0 MS24665103 COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

COTTER PIN

batch: M119096

*[Signature]*

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg D3589

*[Signature]*

17.0 QC5 INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

*[Signature]*

18.0 PACKAGING 1 PACKAGING RESOURCE #1



**FOR ENGINEERING USE ONLY**

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*NA*

19.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*[Signature]*

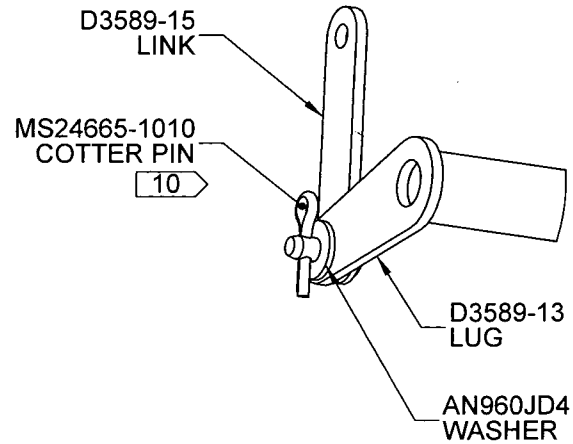
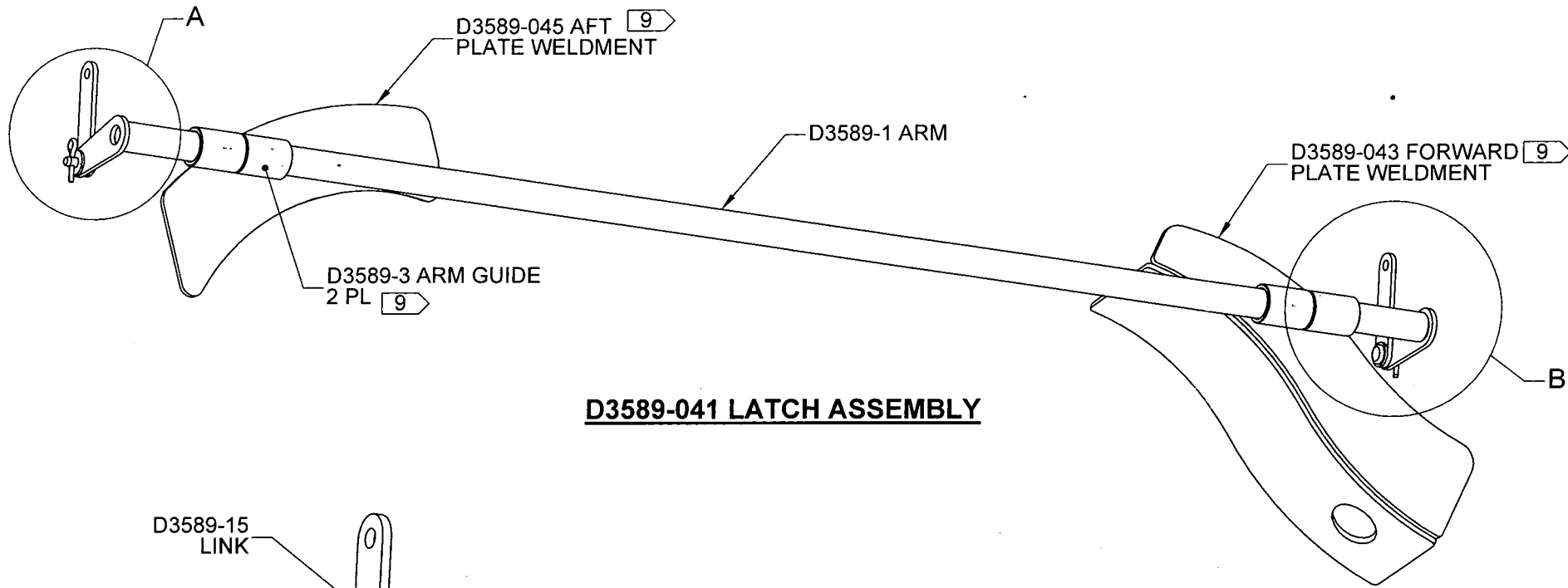
Job Completion



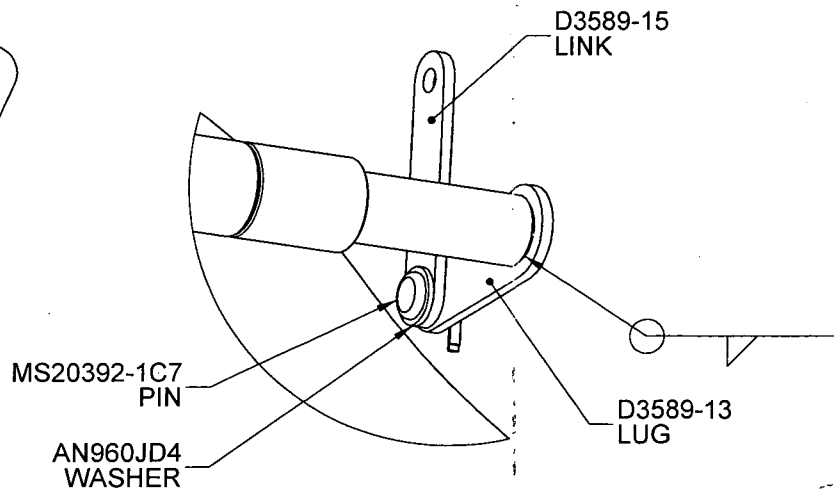
*change to w/o #00224*

*MF 08-06-13*

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN



DETAIL A: LINK ASSEMBLY DETAIL  
SCALE 2X  
2 PL



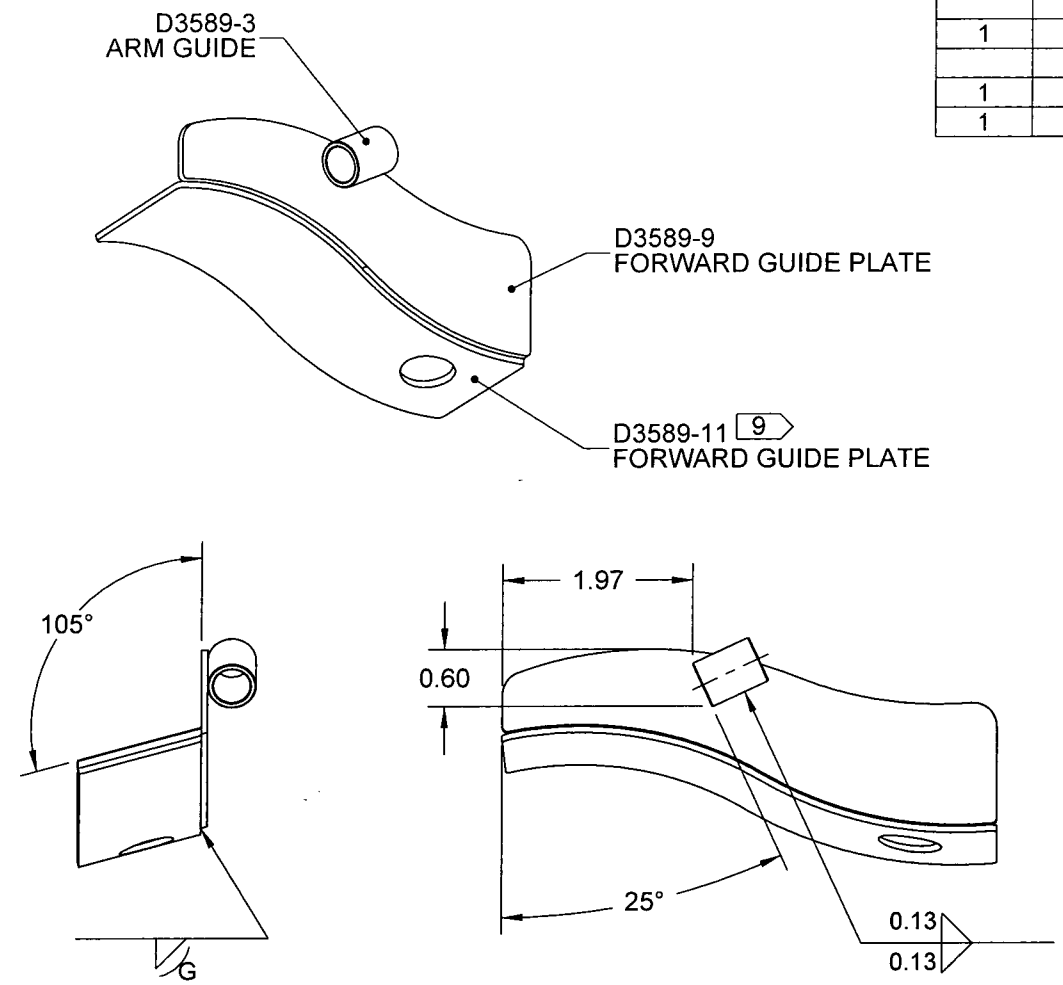
DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL  
SCALE 2X  
2 PL

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
18-06-05

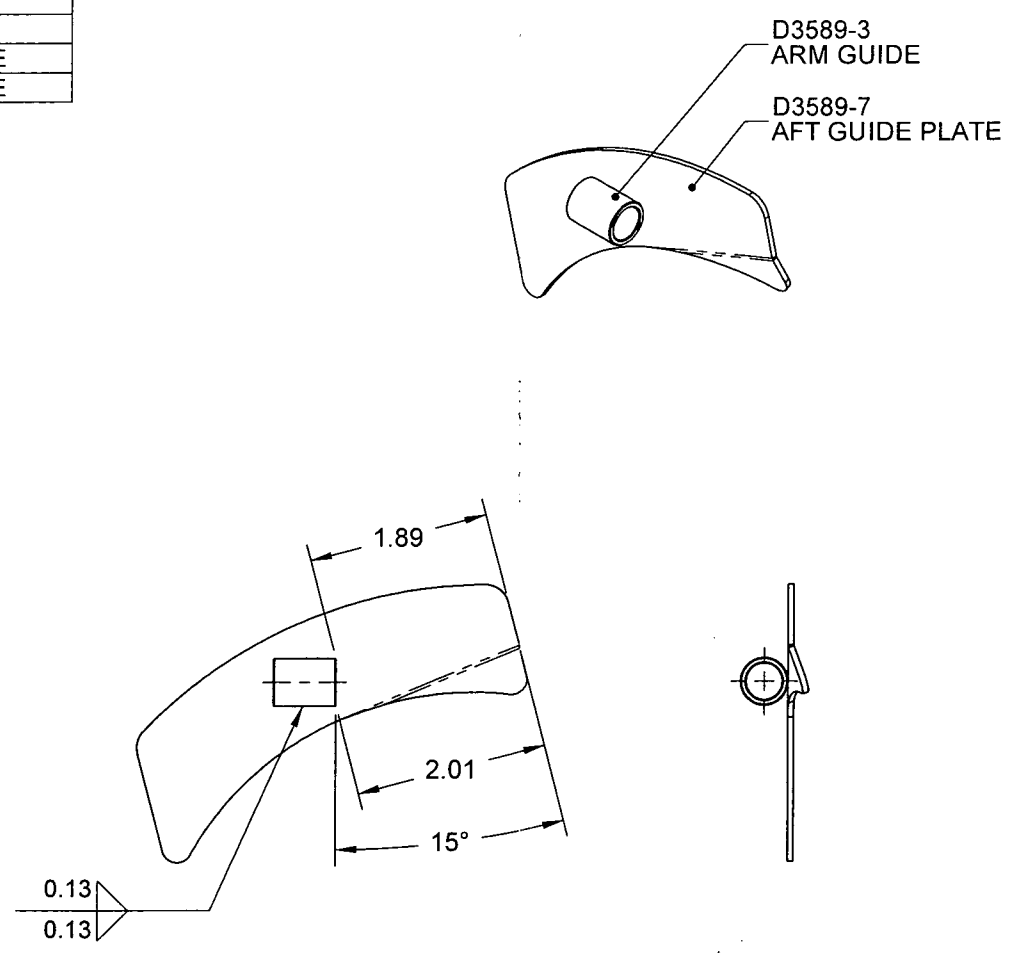
- D3589-041 NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.74 lbs
  - 8) WELDING: PER DART QSI 004
  - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
  - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3589	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

- D3589-043/-045 NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT:
    - D3589-043 = 0.23 lbs
    - D3589-045 = 0.10 lbs
  - 8) WELDING: PER DART QSI 004
  - 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
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 12 06-06-05

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D3589	SHEET 2 OF 8
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